

Work Order ID 69139

Tuesday, May 03, 2011 10:53:21 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								
D4042 11-05-05	A								
100	Weld per dwg A/R S.S. rod Batch: 1115770	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

11-05-10 (1x)

11-05-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/4/11



125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX ϕ m-11/05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Start Date:	5/3/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/9/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Powdercoat								
Powder Coating	Memo	0.00							
	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT: 9:00								
	START TIME: 9:00								
	OVEN TEMPERATURE: 400 OF								
	FINISH TIME: 9:30								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								

140	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00							

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

EP 5/05/11 @

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 160511

170

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

0.00

Packaging

W/69132

EP 5/05/11

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 [Signature]
ME
11-05-11

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[illegible]

Required Qty: 1.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581  Mounting Bracket		Manufactured	No			100	Each	12.0000	2	2		11.05.05	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				12					
					66806			12					
✓ D3913-1  Rib		Manufactured	No			100	Each	3.0000	1			11.05.05	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				1					
					68184			1					
				WA006				2					
					68418			2					
✓ D3913-15  Wide Handle Plate		Manufactured	No			100	Each	2.0000	1			11.05.05	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				2					
					68176			2					
✓ D3913-3  Rib		Manufactured	No			100	Each	2.0000	1			11.05.05	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				2					
					68185			2					

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Picklist Print

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Page 2

Work Order ID: 69139

Parent Item: D3913-041


Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011


Required Date: 5/9/2011

Start Qty: 1.00


Required Qty: 1.00


✓ D3913-7 Manufactured No 100 Each 10.0000 2 2

 Rib

Location	Loc Qty	Loc Code
WA006	10	
65278	1	
66435	1	
67982	2	
68417	6	

✓ D3913-9 Manufactured No 100 Each 5.0000 1 1

 Hinge Rib

Location	Loc Qty	Loc Code
WA006	5	
68186	2	
68590	3	

✓ D3916-041 Manufactured No 100 Each 0.0000 2 2

 Rib Assembly

✓ D3916-5 Manufactured No 100 Each 7.0000 3 3

 Light Rib

Location	Loc Qty	Loc Code
WA006	7	
68155	7	

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Tuesday, May 03, 2011 10:53:29 AM

[illegible][illegible]

Required Date: 5/9/2011

Required Qty: 1.00



3 *11.05.05*

18



¹ 11.05.05

3



2 11.05.05

6



11.05.05

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W/O:		WORK ORDER CHANGES						
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Work Order ID: 69139

Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011

Required Date: 5/9/2011



Start Qty: 1.00

Required Qty: 1.00

✓ D4021-1 Manufactured No 100 Each 13.0000 3 3

 Handle Plate
 11.05.05



Location Loc Qty Loc Code



WA 13
 67474 3
 68424 10

/ D4034-041 Manufactured No 100 Each 1.0000 1 1

 Aft Upper Rib Assembly
 11.05.05

Location Loc Qty Loc Code



WA006 1
 66884 1

/ D4034-043 Manufactured No 100 Each 0.0000 1 1

 Fwd Upper Rib Assembly
 11.05.05

✓ M304EX0.75-16F Purchased No 100 sf 583.3016 33 33

 Expanded Metal Flat SS
 11.05.05

Location Loc Qty Loc Code

WA 583.3016
 115012 114
 117197 182.3016
 117455 287

AN3-10A Purchased No 150 Each 89.0000 6 6

 Bolt
 11.05.11

Location Loc Qty Loc Code

ST351 89
 117313 89

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Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

*AN960JD8, NAS1149DN832J Purchased No

 Washer
 D2931

 Bumper

4 M117316
 Manufactured No

150 Each

0.0000

2



2
 5/5/11

150 Each

680.0000

2



2
 5/5/11

Location

Loc Qty

Loc Code

ST504

680

46064

680

D4021-5 Manufactured No

150 Each

12.0000

2



2
 5/5/11

Blanking Plate

Location

Loc Qty

Loc Code

ST110

10

68261

10

WA005

2

67008

2

MS20600-AD4W3 Purchased No

150 Each

1,185.000

2



2
 5/5/11

Cherry Rivets

Location

Loc Qty

Loc Code

ST321

860

111636

360

117505

500

WA018

325

107939

325

2

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

2,079.000

6



Nut

6
5/11/05/11

Location

Loc Qty

Loc Code

ST300

2079

116391

11

116540

502

116549

766

117441

800

6

NAS1149F0332P

Purchased

No

150

Each

124.0000

12



WASHER

12
5/11/05/11

Location

Loc Qty

Loc Code

ST275

124

17317

124

12

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

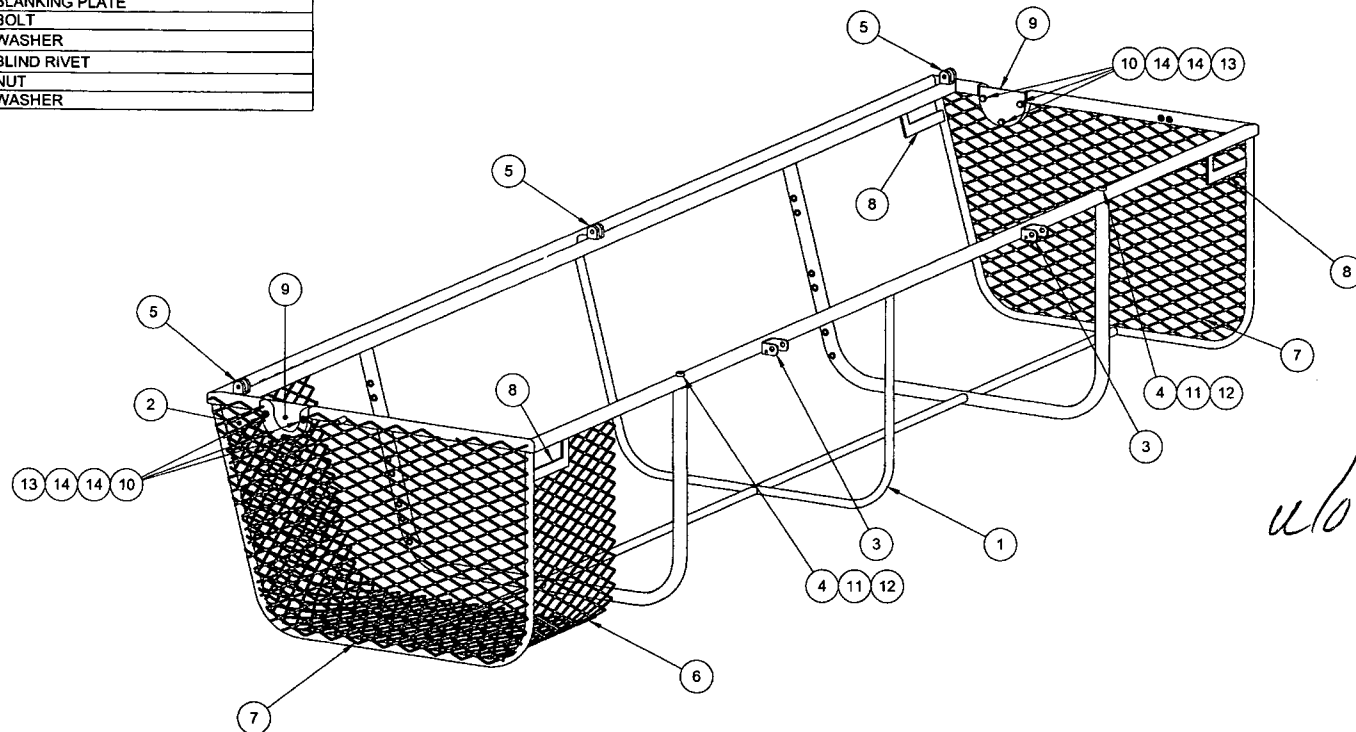
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. A
TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D8-2
D4020-1
MESH

D3913-101
TUBULAR ASSY

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL 8

D2581
MOUNTING BRACKET
2 PL

D4021-1
HANDLE PLATE

D4016-1
HINGE HALF, BASE
3 PL

D4021-1
HANDLE PLATE
2 PL

D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/U 69139

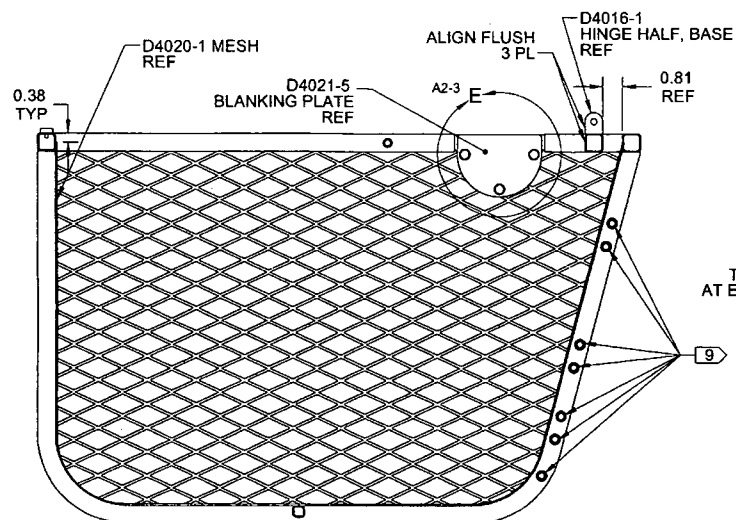
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

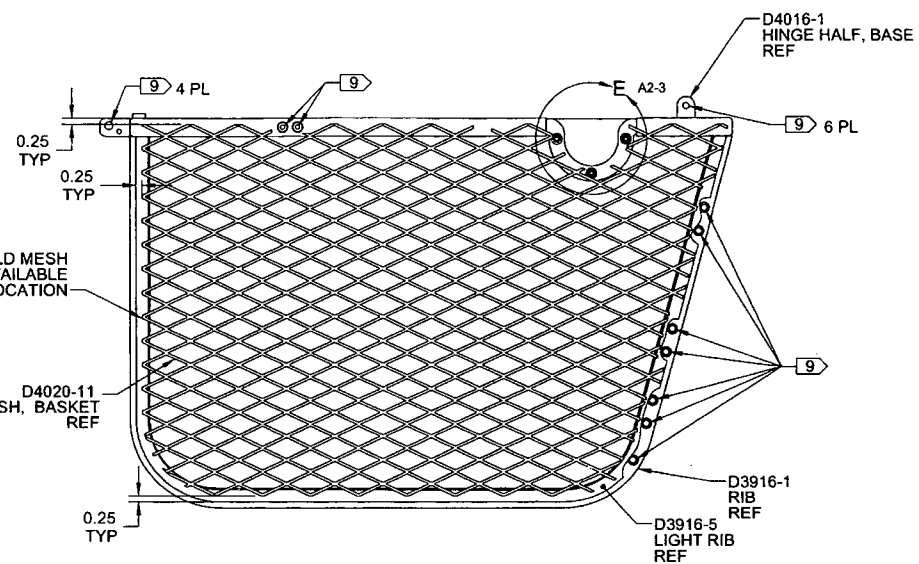
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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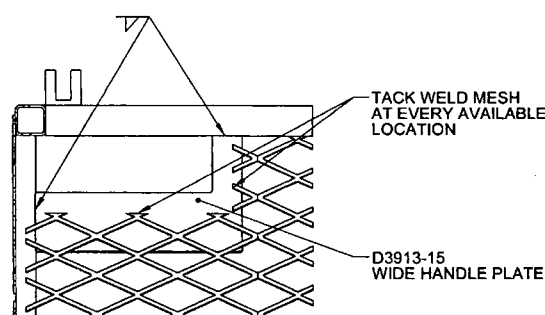
NOTE: Date & initial all entries



SECTION A-A A5-2

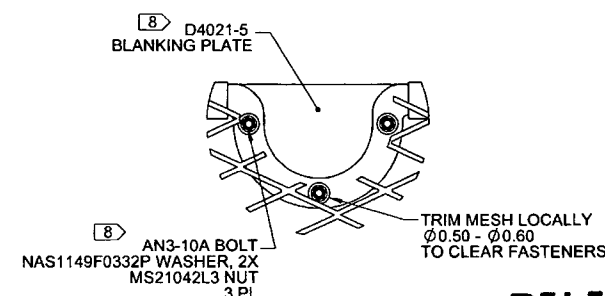


VIEW B-B A2-2







SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES

w/o CA139



DETAIL D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

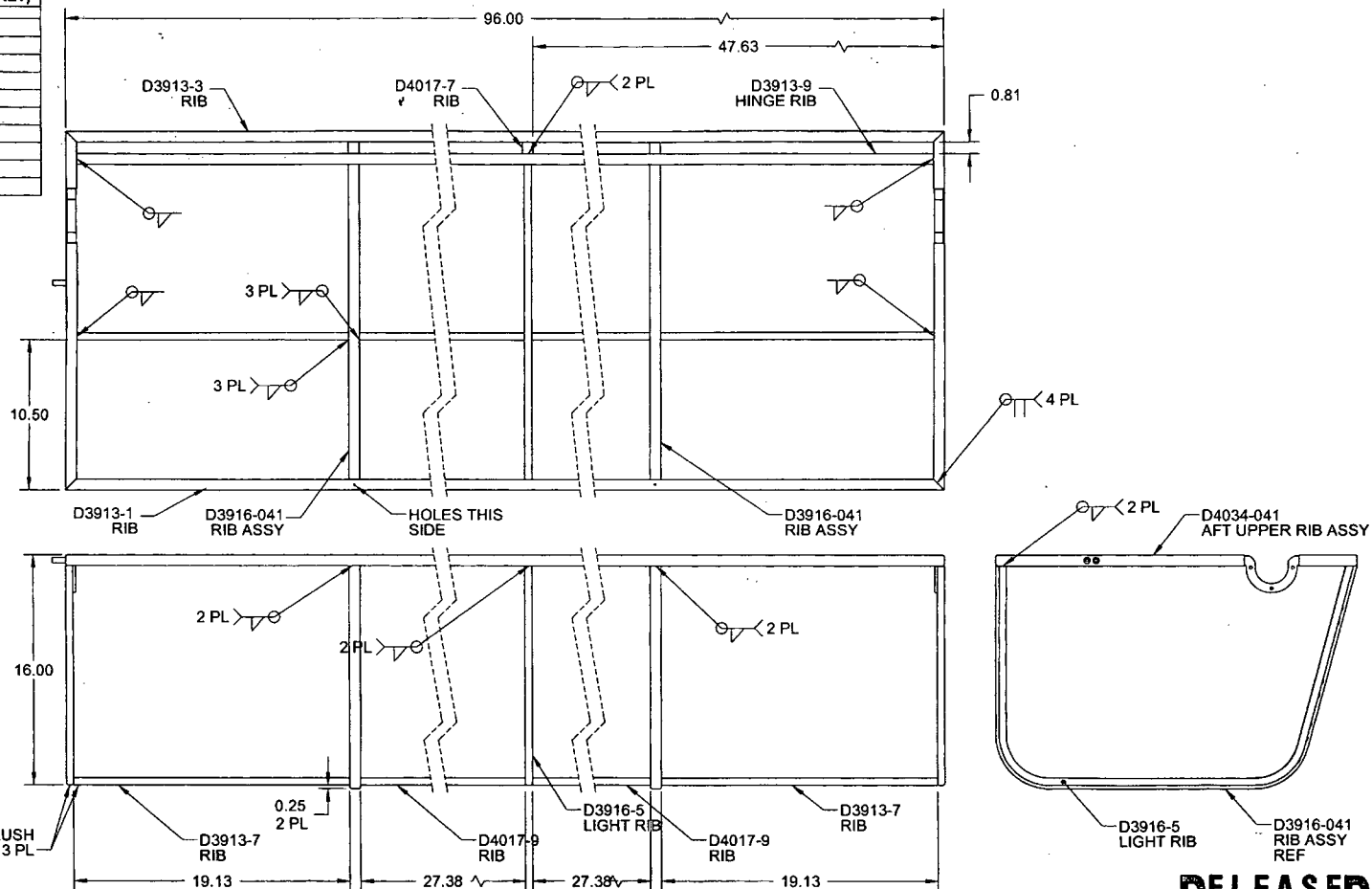
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		

w/69139

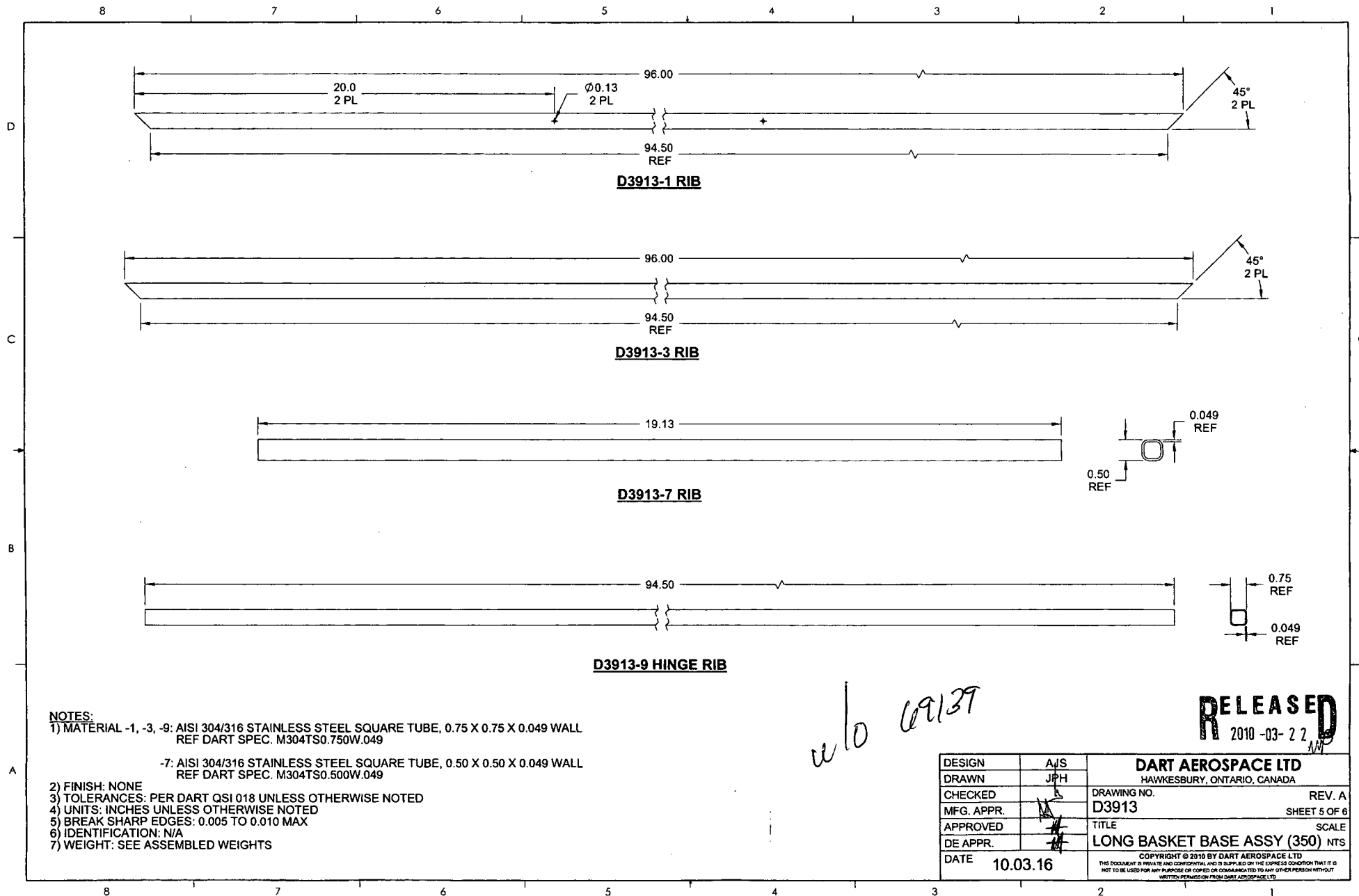
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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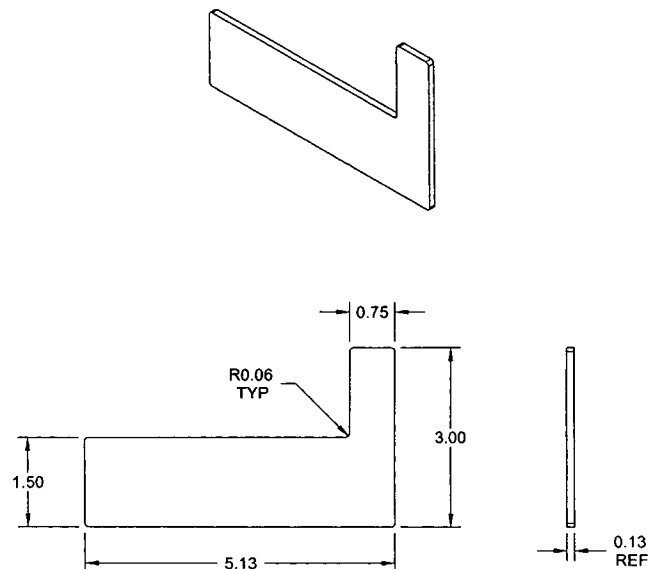
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.			SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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RELEASED
2010-03-22

u/o 69139

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries